

Date: Friday, 1/6/2006 1:48:15 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 206L/407 STEP ASSY, RH		
Job Number	: 25410A			Part Number	: D2724042		
Estimate Number	: 11703			Drawing Number	: D2724 REV C		
P.O. Number	: N/A			Project Number	: N/A		
This Issue	: 1/6/2006 S.O. No. : N/A			Drawing Revision	: C		
Prsh Rev.	: NC			Material	: N/A		
First Issue	: N/A Type : LARGE FAB ASSY			Due Date	: 1/13/2006 Qty: 3 Um: Each		
Previous Run	: N/A						
Written By	: SEE COMMENT BELOW						
Checked & Approved By	: SEE COMMENT BELOW						
Comment	: Est Rev:E As Per Ecn 766 06-01-06 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2622120C	Extrusion	
Comment:	Qty.: 1.0000 Each(s)/Unit	Total : 3.0000 Each(s)	
Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<u>324092</u>
Check Material for any Dents or Defects			
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
Comment:	Setup: 0.00Hrs/ Run: 0.0000Min	Total Run : 0.0000Hrs	
LARGE FABRICATION RESOURCE 1			
Cut D2724-2 using D2622 extrusion as per Dwg D2724			
Deburr and bevel ends for welding			
3.0	D2734	206 Step Endplate	
Comment:	Qty.: 2.0000 Each(s)/Unit	Total : 6.0000 Each(s)	
206 Step Endplate			
Pick:			
Qty	Part Number	Description	Batch
2	D2734	End Cap	<u>320757</u>
4.0	D34581	PLATE	
Comment:	Qty.: 2.0000 Each(s)/Unit	Total : 6.0000 Each(s)	
Pick:			
Qty	Part Number	Description	Batch
2	D3458-1	Plate	<u>325418 = 5 pcs</u> <u>325209 = 1 pcs</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206L/407 STEP ASSY, RH

Job Number: 25410A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0 D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3458-3

cPlate 325210 = 10 325417 = 2

Lb 06-01-10 3

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig
DT (One End Only)

A/R AL ROD Batch: 111838 111839

Grind end cap welds flush

Lb 06-01-11 3

7.0 QC5/9

WELD INSPECTION



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

WELD INSPECTION

PD 06-01-11
J 06-01-11

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JF 06-01-11

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



J 06-01-11 3

Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



J 06-01-11 3

Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 25410A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remainig end cap as per Dwg D2724 using Jig DT followed by Jig-
DT
A/R AL ROD Batch: m18839

LE 06-01-11

3

11.0 QC5/9

WELD INSPECTION



PD
06-01-11



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

WELD INSPECTION

12.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

HAND FINISHING RESOURCE #1

3

Touch up Alodine

FF 06-01-12

13.0 POWDER COATING

POWDER COATING



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

ML 06-01-15 3

14.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Wing Walk as per Dwg D2724 and QSI 00 5 4.4

ML 06-01-15 3

16.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

INSPECT POWDER COAT/CHEMICAL CONVERSION

CL 06/01/18 (3)

17.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

PACKAGING RESOURCE #1

Identify and Stock

CL 06/01/18 (3)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:



Seq. #:

Machine Or Operation:

Description :

Location: ✓

18.0

DC

DOCUMENT CONTROL



Comment: Setup: 0.00Hrs/ Run: 0.000Hrs Total Run : 0.0000Hrs

DOCUMENT CONTROL

Inspection Level 21

06/01/18

Job Completion



06.01.18

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries